

Work Order ID 52367

Tuesday, September 22, 2009 3:13:09 PM



Page 1

Item ID: D3121-144

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

mmf

Date: 09-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID/	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3121

Rev E

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 2.000") 4.425" long

SL 09/10/04

8

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114□2-Deburr□3-Scribe batch number

mmf 09/10/07 / SL 09/10/08

8

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

mmf 09/10/07 / SL 09/10/08

8

Work Order ID 52367

Tuesday, September 22, 2009 3:13:09 PM



Page 2

Item ID: D3121-144

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>JS 09/10/08</i>			<u>6</u>			
140 Small Fab Small Fab	Small Fab Memo Assemble D3121-143 as per Dwg D3121.	0.00 0.00				<i>JS 09/10/19</i> <u>(6)</u>			
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>JS 09/10/19</i>			<u>(6)</u>	<i>f</i>		

Work Order ID 52367

Tuesday, September 22, 2009 3:13:09 PM



Page 3

Item ID: D3121-144

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket Assembly

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>235</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
170	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

9/10/19 (5) 50

09/10/19 [Signature]

MF 09-10-19

Picklist Print

Tuesday, September 22, 2009 3:13:09 PM

Page 1

Work Order ID: 52367



Parent Item: D3121-144RevE

Parent Item Name: Bracket Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3121-241RevE Manufactured No



Bearing Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46169

34

34

B52717

(2x)

B52592

(10x)

9/29/10/19

D3121-21RevE Manufactured No



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46032

50096

57

17

40

B52518

9/29/10/19

M174B1.250X02.000 Purchased No



17-4 SS Bar 1.250 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109851

111787

28.56

4.56

24

23272

SL 09/10/09

DART AEROSPACE LTD		Work Order:	52367
Description: Bracket		Part Number:	D3121-114
Inspection Dwg: D3121 Rev: E		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

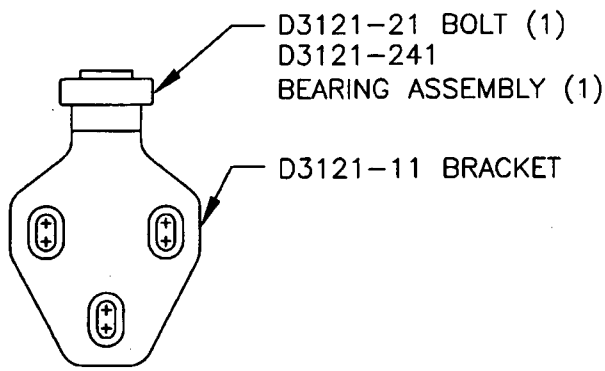
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.300	+/-0.010	0.295	✓			
R0.375	+/-0.010	0.375	✓			
1.54	+/-0.030	1.55	✓			
0.350	+/-0.010	0.353	✓			
R0.25	+/-0.030	0.25	✓			
Ø0.392	+0.002/-0.000	0.393	✓			
Ø0.201	+0.005/-0.000	0.201	✓			
0.100	+/-0.010	0.096	✓			
2.540	+/-0.010	2.538	✓			
1.590	+/-0.010	1.589	✓			
0.160	+/-0.010	0.160	✓			
0.400	+/-0.010	0.399	✓			
1.220	+/-0.010	1.224	✓			
1.600	+/-0.010	1.601	✓			
3.80	+/-0.030	3.80	✓			
1.800	+/-0.010	1.800	✓			
R0.50	+/-0.030	0.50	✓			
0.130	+/-0.010	0.128	✓			
3.41	+/-0.030	3.42	✓			
3.65	+/-0.030	3.66	✓			
2.24	+/-0.030	2.21	✓			
45°	+/-0.1°	45°	✓			
R0.25	+/-0.030	0.25	✓			
3.97	+/-0.030	3.96	✓			
R0.38	+/-0.030	0.38	✓			
Ø0.392	+0.002/-0.000	0.393	✓			
Ø0.201	+0.005/-0.000	0.201	✓			
0.268	+/-0.010	0.270	✓			
R0.260	+/-0.010	0.250	✓			
0.080	+/-0.010	0.085	✓			
0.300	+/-0.010	0.300	✓			
0.381	+/-0.010	0.380	✓			
0.201	+/-0.010	0.201	✓			

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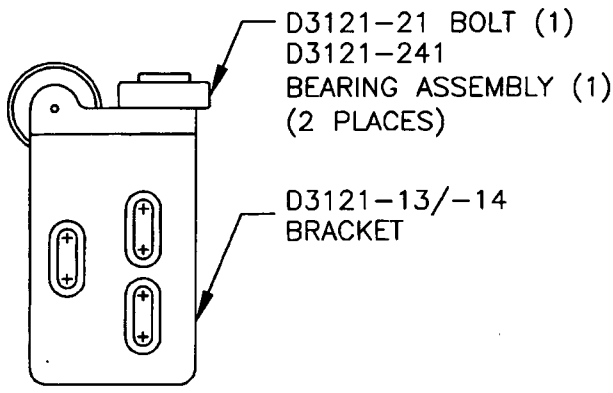


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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

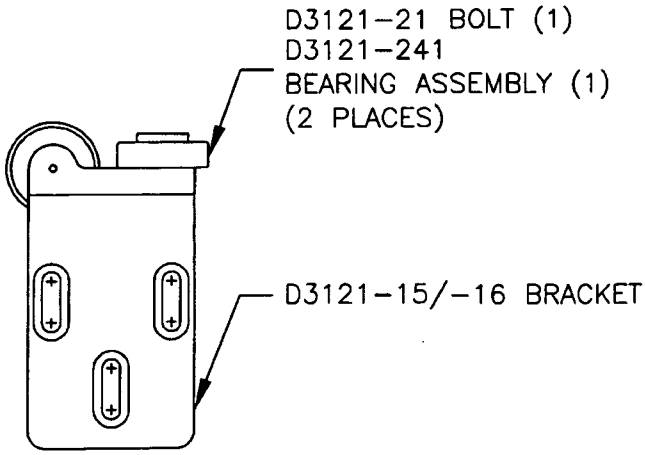
RELEASED
 07.11.07



D3121-041 BRACKET ASSEMBLY
 (REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
 (REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
 (REPLACES PREMIER P/N B30-23000-35/-36)

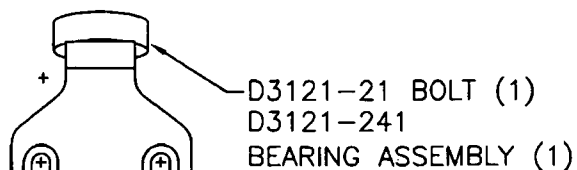
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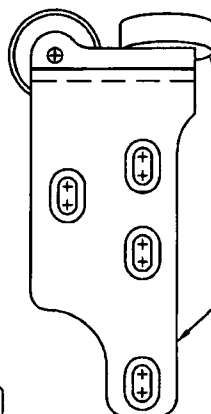
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY

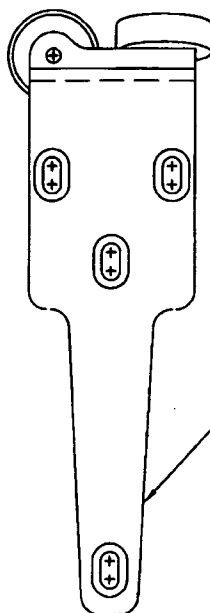
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07 W

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-115/-116 BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-05/-06)

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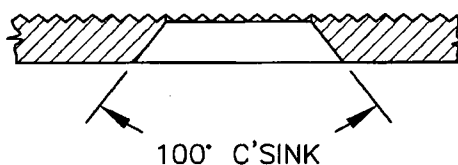
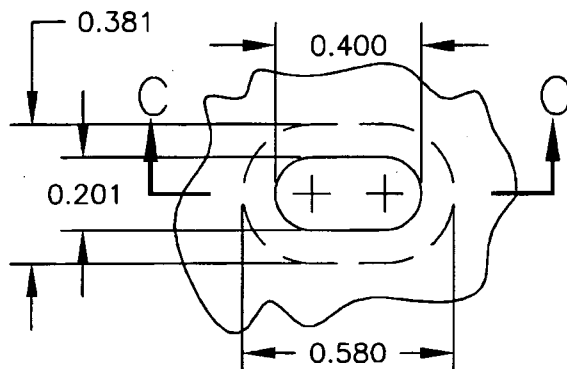
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

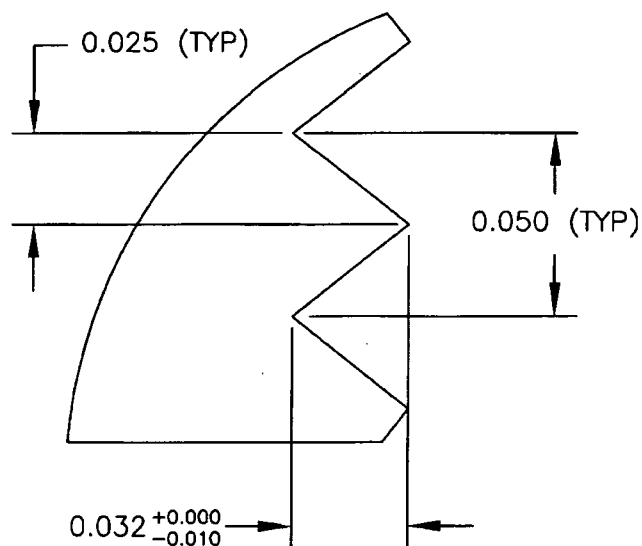
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

RELEASED
07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



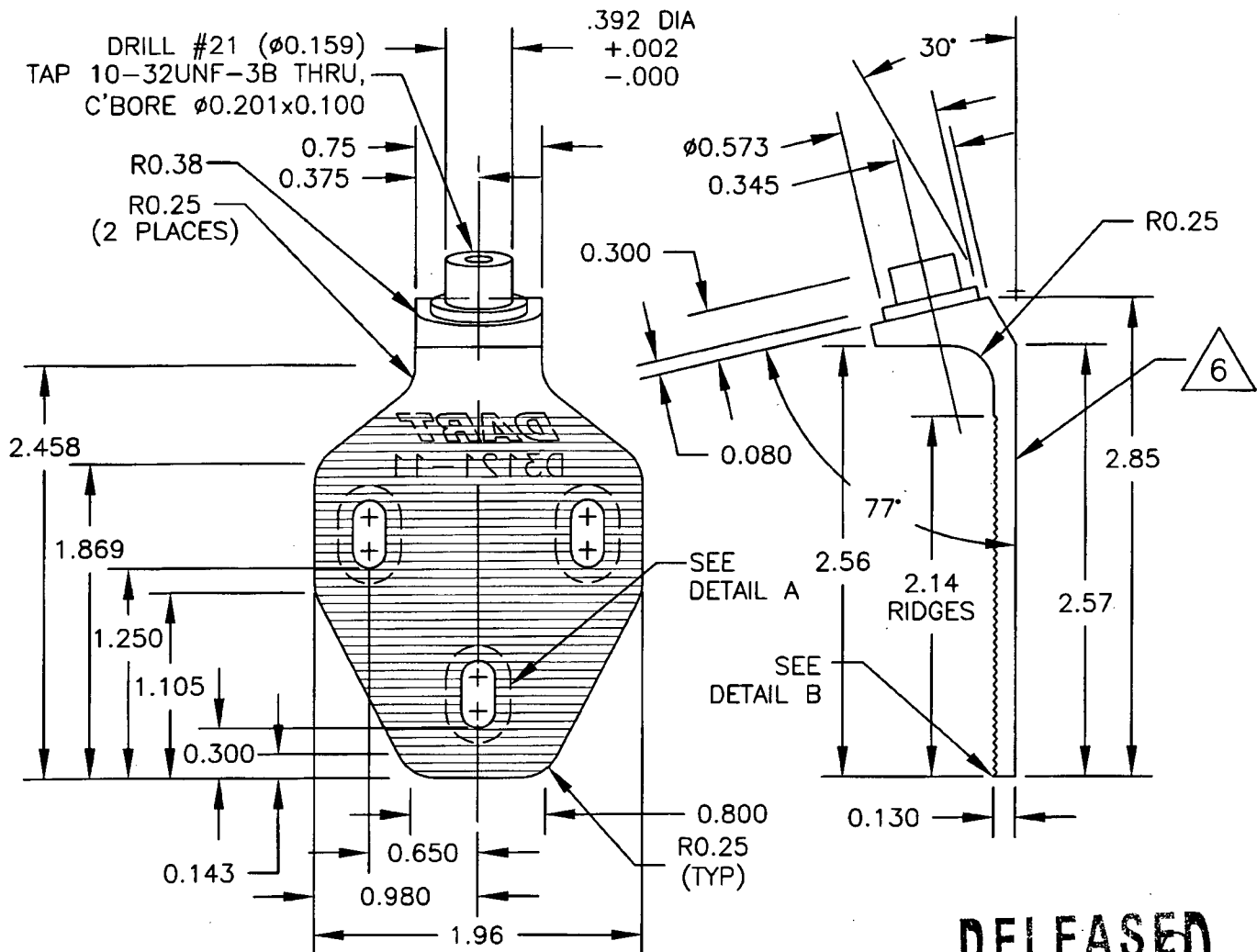
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1



RELEASED
07.11.07

D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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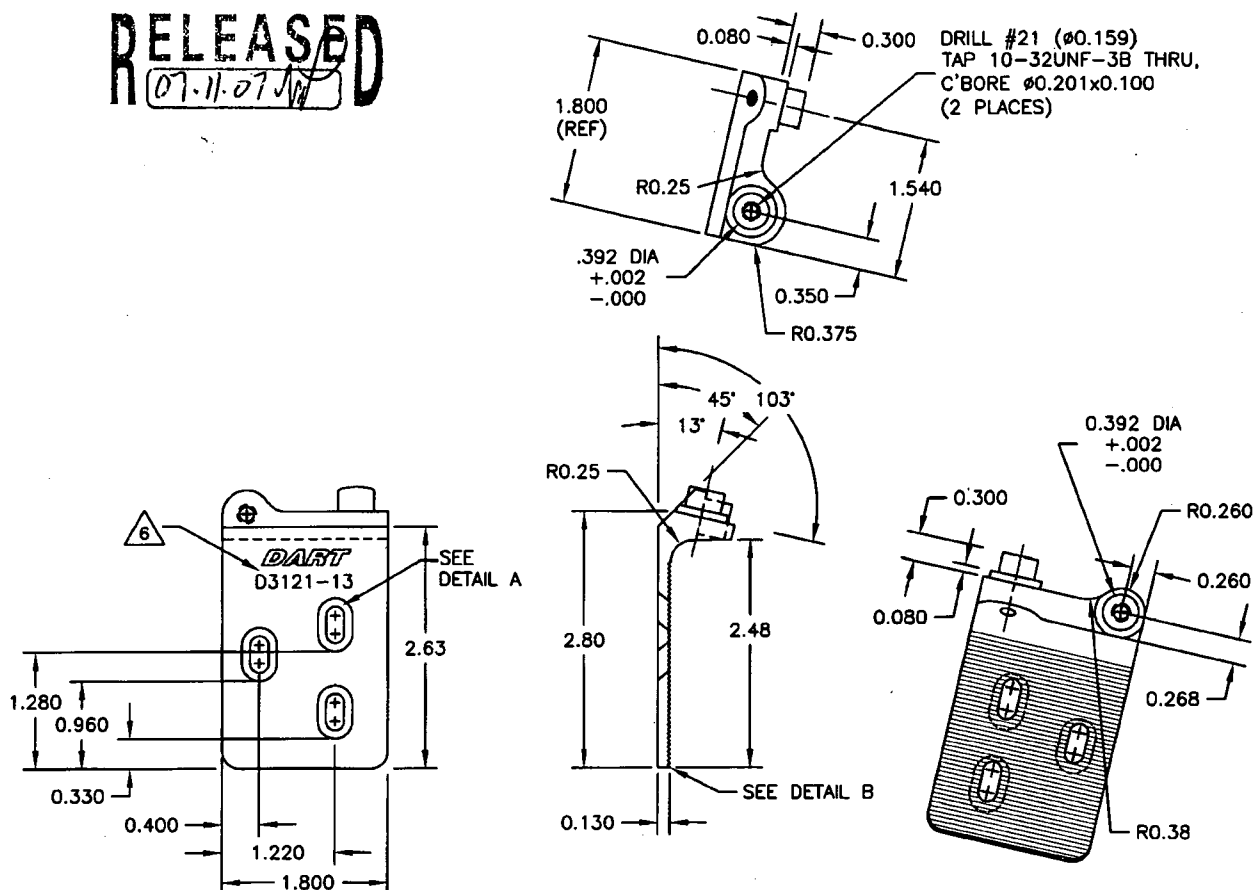
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5023607



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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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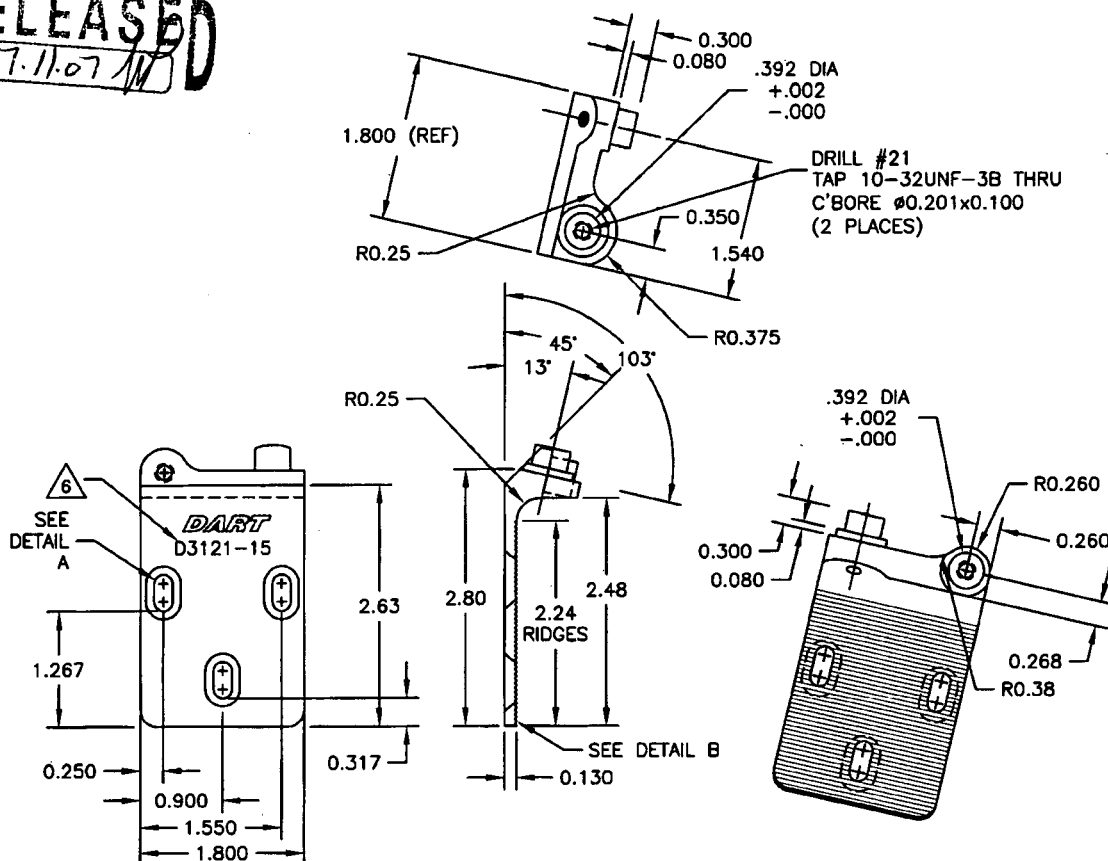
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07



D3121-15 BRACKET (SHOWN)

D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

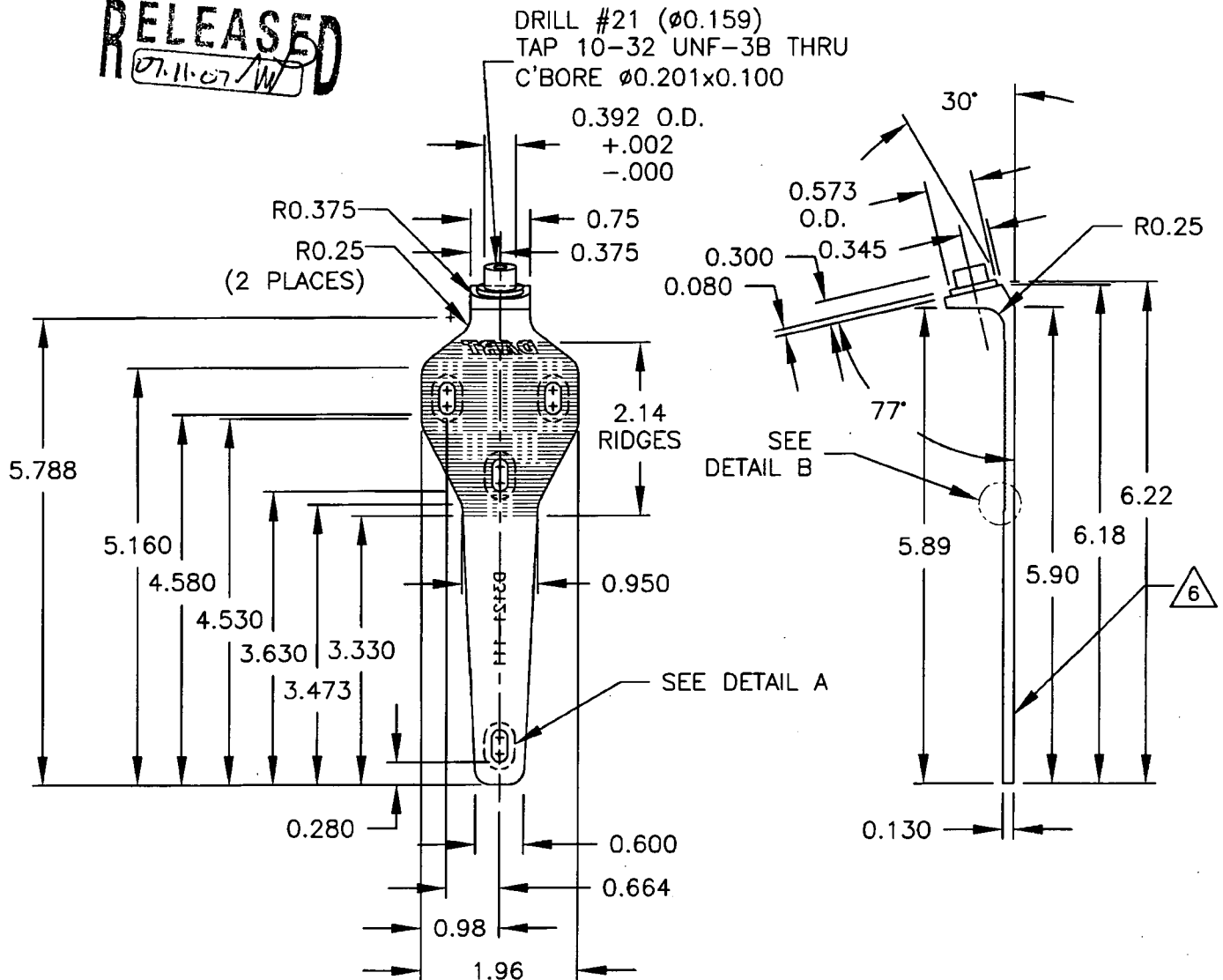
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07/W**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

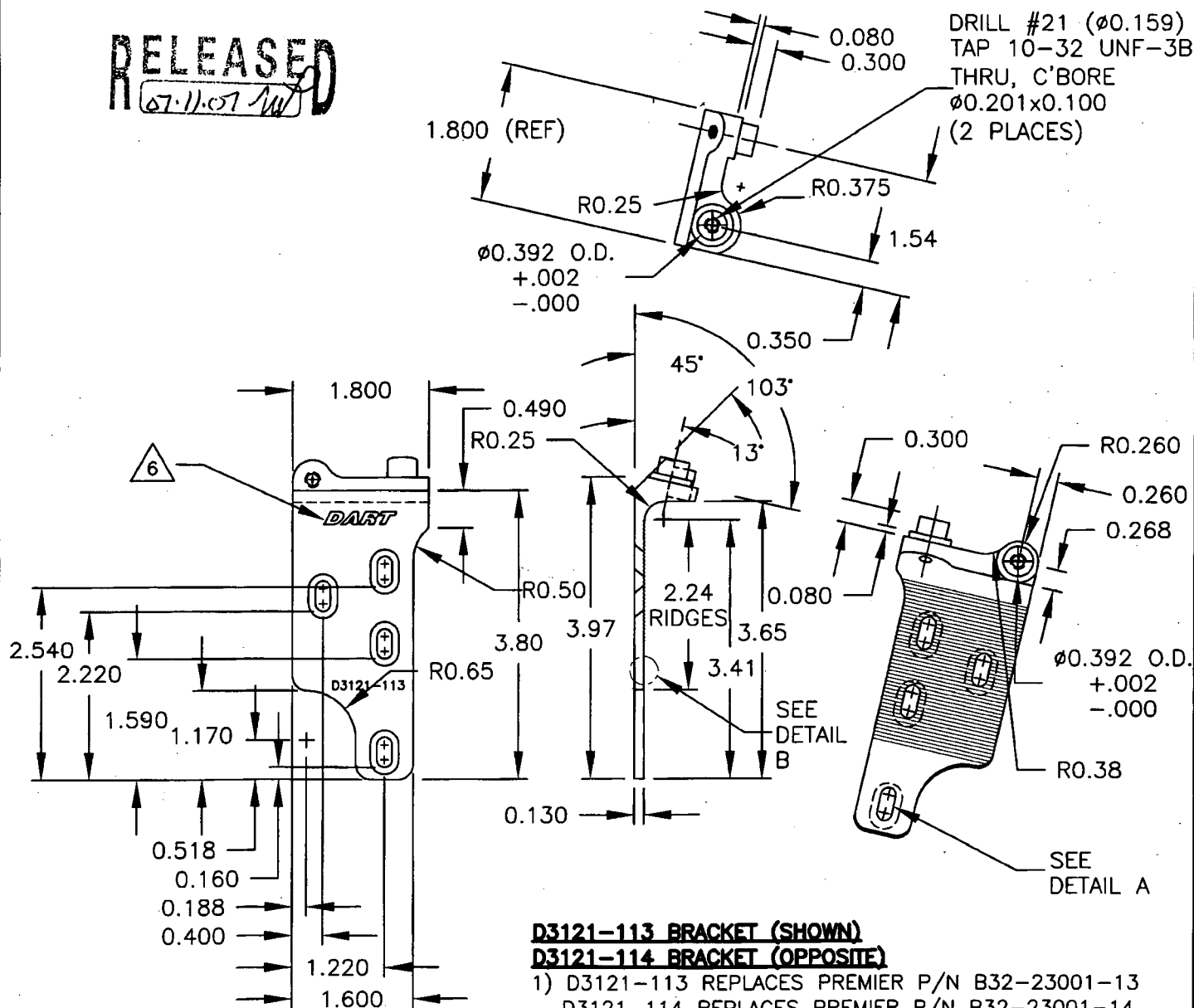
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

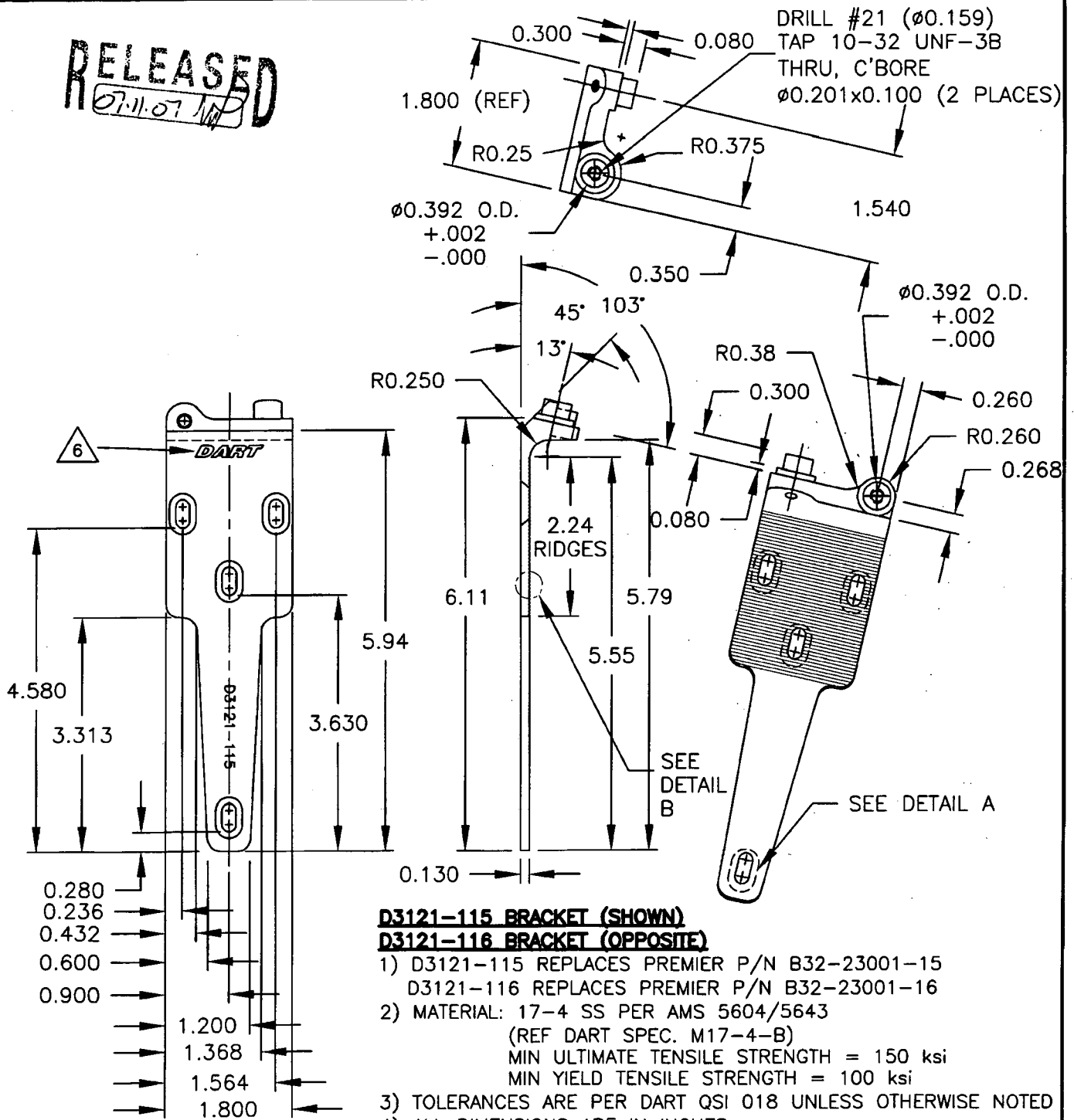
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07

D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

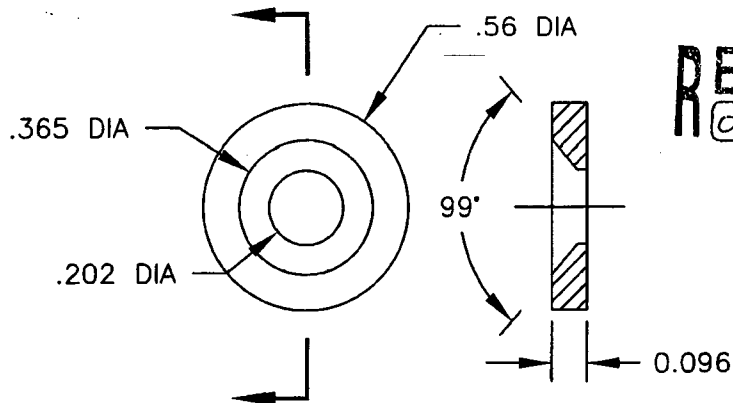
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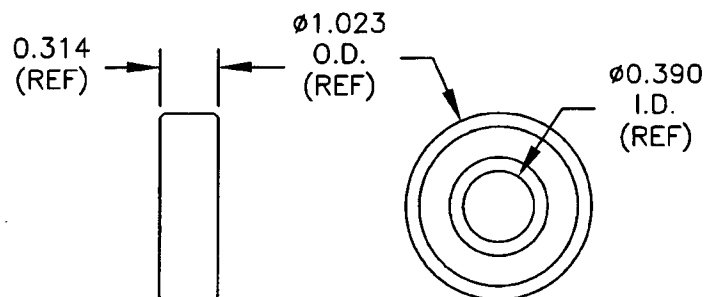
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DART

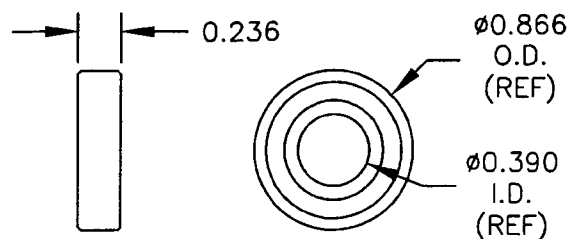
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

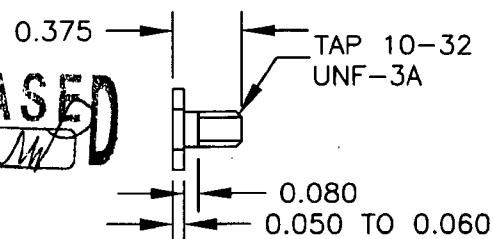
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

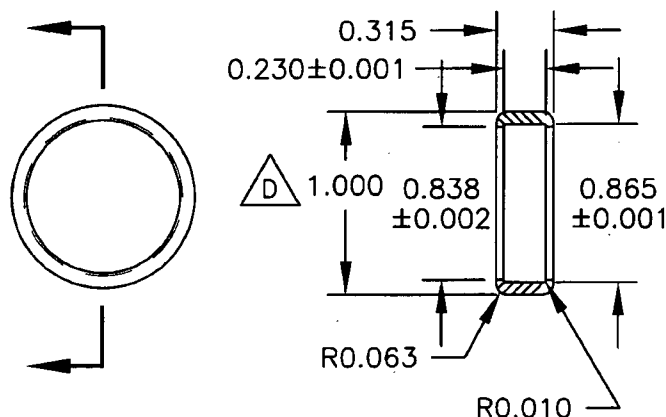
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

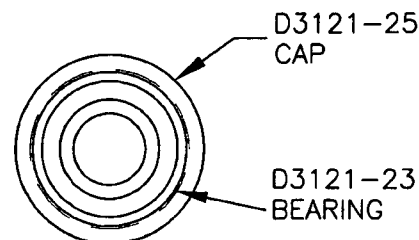
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-22 OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, $\phi 1.25$ (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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